

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 73.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004614**Date Inspected:** 10-Nov-2008**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** HoChang, Korea**OSM Arrival Time:** 800**OSM Departure Time:** 1700**Location:** Unyang, Korea

CWI Name:	N/A		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No
Weld Procedures Followed:	Yes	No
Verified Joint Fit-up:	Yes	No
Approved WPS:	Yes	No
Delayed / Cancelled:	Yes	No

Bridge No: 34-0006**Component:** Pier E2 bearing and Shear key**Summary of Items Observed:**

The following report is based on METS observations at HoChang Machinery Industries. Current work: Casting, forging and machining.

On this date the Caltrans Quality Assurance (QA) inspector, Dong J. Shin arrived at Ho Chang Machinery Industries (HCMI) located at Unyang, Korea. The Purpose of this trip was to observe quality control during fabrication and processing of the following items.

Forging

1. Bearing Bottom Housing (B1-07/F07302-010): Completed normalizing and heat treating
2. Bearing Bottom Housing (B2-07/F07302-020): Completed normalizing and heat treating
3. Bearing Bottom Housing (B3-07/F07302-030): Completed normalizing and heat treating
4. Bearing Bottom Housing (B4-07/F07302-040): Completed normalizing and heat treating
5. Spherical Ring (S1-07/F07302-050): Move to HCMI for rough machining.
6. Spherical Ring (S2-07/F07302-060): Move to HCMI for rough machining.
7. Spherical Ring (S3-07/F07302-070): Move to HCMI for rough machining.
8. Spherical Ring (S4-07/F07302-080): Move to HCMI for rough machining.
9. Solid Shaft (B1-02/F07302-090): Ship back to Doo San for cut in to two pieces. One piece was over weight for milling machine.
10. Solid Shaft (B2-02/F07302-100): Ship back to Doo San for cut in to two pieces. Single piece was over weight for milling machine.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

11. Solid Shaft (B3-02/F07302-110): Completed normalizing and heat treating
12. Solid Shaft (B4-02/F07302-120): Completed normalizing and heat treating

- F number is Doo San Production Number.
- B number is drawing Number .

Casting

1. Bearing Top Housing(B1-06, C07039-010): Pattern making
2. Bearing Top Housing(B2-06, C07039-020)
3. Bearing Top Housing(B3-06, C07039-030)
4. Bearing Top Housing(B4-06, C07039-040)
5. Bearing Hold Down Assembly (B1-01-1, C07039-050)Pattern making
6. Bearing Hold Down Assembly (B1-01-2, C07039-060)Pattern making
7. Bearing Hold Down Assembly (B2-01-1, C07039-070)
8. Bearing Hold Down Assembly (B2-01-2, C07039-080)
9. Bearing Hold Down Assembly (B3-01-1, C07039-170)
10. Bearing Hold Down Assembly (B3-01-2, C07039-180)
11. Bearing Hold Down Assembly (B4-01-1, C07039-190)
12. Bearing Hold Down Assembly (B4-01-2, C07039-200)
13. Shear Key Stub(S1-01, C07039-090) : Pattern making
14. Shear Key Stub(S2-01, C07039-100) :
15. Shear Key Stub(S3-01, C07039-110) :
16. Shear Key Stub(S4-01, C07039-120) :
17. Shear key Housing(S1-03, C07039-130): pattern making
18. Shear key Housing(S1-03, C07039-130): pattern making
19. Shear key Housing(S1-03, C07039-130):
20. Shear key Housing(S1-03, C07039-130):

* S and B number is drawing number.

* C number is DSHI ID number

* Blank is not started.

Summary of Conversations:

Discussed Mr. S. H. Kwak regarding current status of NDE procedure and fabrication procedure comments.

Checked machining schedule of Spherical ring with Mr. S. H. Kwak.

Reviewed production schedule of casting.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jinesh K, Mehta (951) 840-0541, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By: Shin,DJ

Quality Assurance Inspector

Reviewed By: Lanz,Joe

QA Reviewer